

Date: Thursday, 9/14/2006 7:29:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 28571		
Estimate Number	: 12155		
P.O. Number	: <i>N/A</i>	Part Number	: D34791
This Issue	: 9/14/2006 S.O. No. <i>N/A</i>	Drawing Number	: D3479 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 26996	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/6/2006
Checked & Approved By	: <i>FF 06.09.14</i>	Qty:	<i>8</i> Um: Each
Comment	: Est Rev:A New Issue 06-02-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.1470 f(s)/Unit Total : 0.5880 f(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: *M10100**1.18**W**FF 06.09.18**8*

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut Flat pattern 2.50" X 8.50" as per Dwg D3479

*70**?**FF 06.09.18**8*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll part as per Dwg D3479

3-Spot weld as per Dwg D3479 and Dart QSI 018

4-Fabricate Bead using Rotary Machine as per Dwg D3479 +Form

*FF 06.09.18**8**SB 06/09/25**8*

4.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION & Work to Current Step

*R**11/06/09/25 (8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:29:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 28571

Part Number: D34791

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: ~~PACKAGING RESOURCE #1~~

Location: ST446
I.D. in stock

RB 06/09/26

(8)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RB 06/09/26

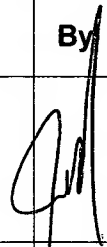
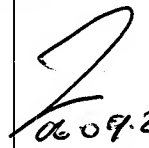
(8)


Job Completion



RB 06/09/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-09-26	50	Make change (permanently) to I.D. & stock items.					 06-09-26

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/09/26
QA: N/C Closed: _____ Date: _____

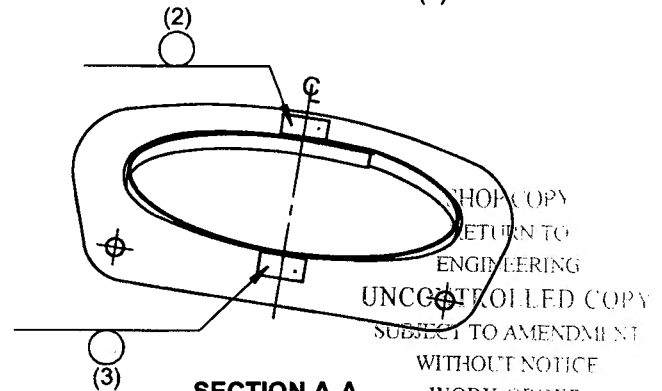
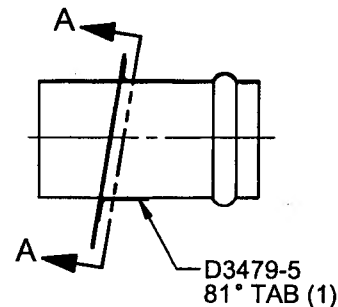
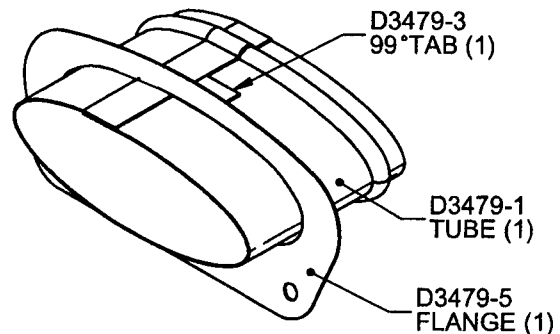
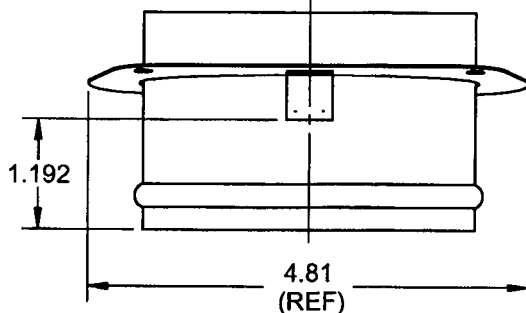
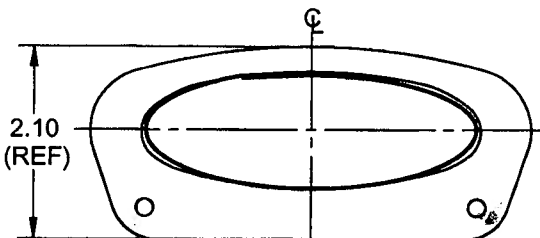
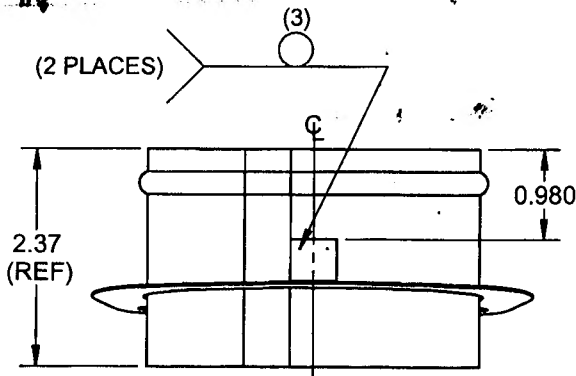
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3479	REV. A SHEET 1 OF 4
DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	

06.04.03



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D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

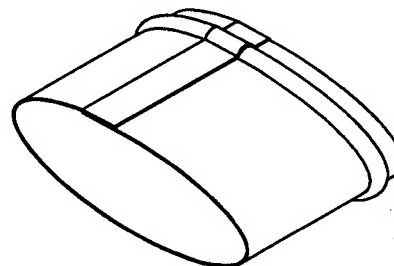
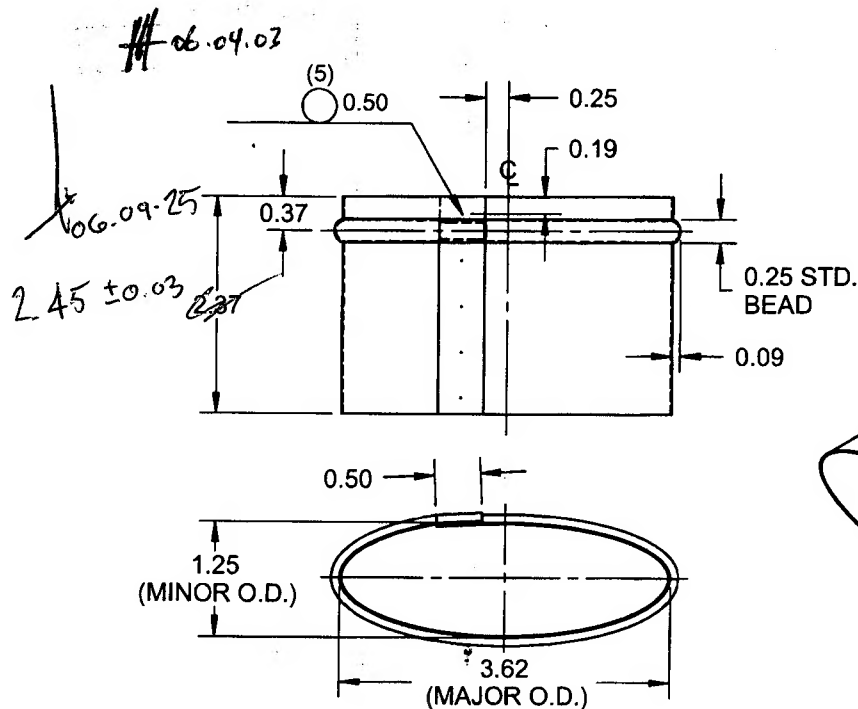
QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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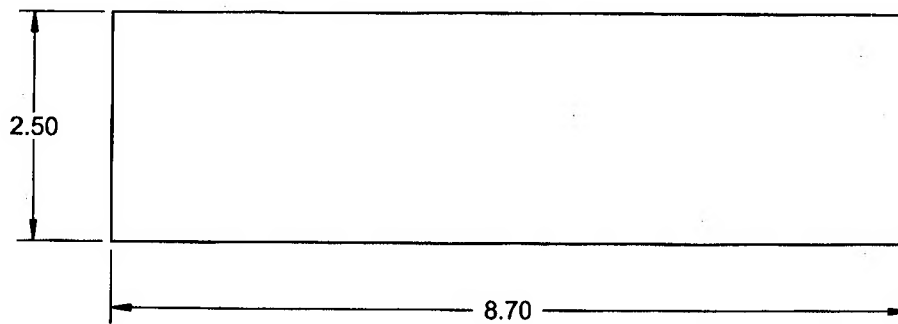
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DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2



D3479-1 TUBE



D3479-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

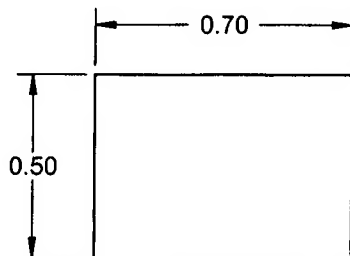
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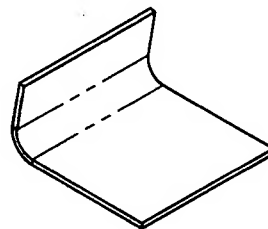
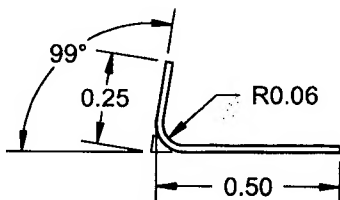
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. A SHEET 3 OF 4
DATE 06.01.19		TITLE ADAPTER INLET	SCALE 2:1



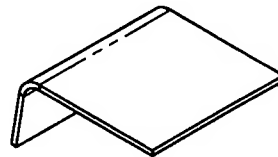
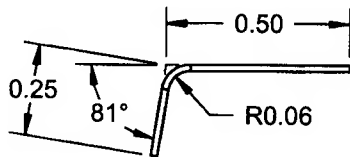
[Signature] 06.04.03

D3479-3F FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)



D3479-3 99 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)



D3479-5 81 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

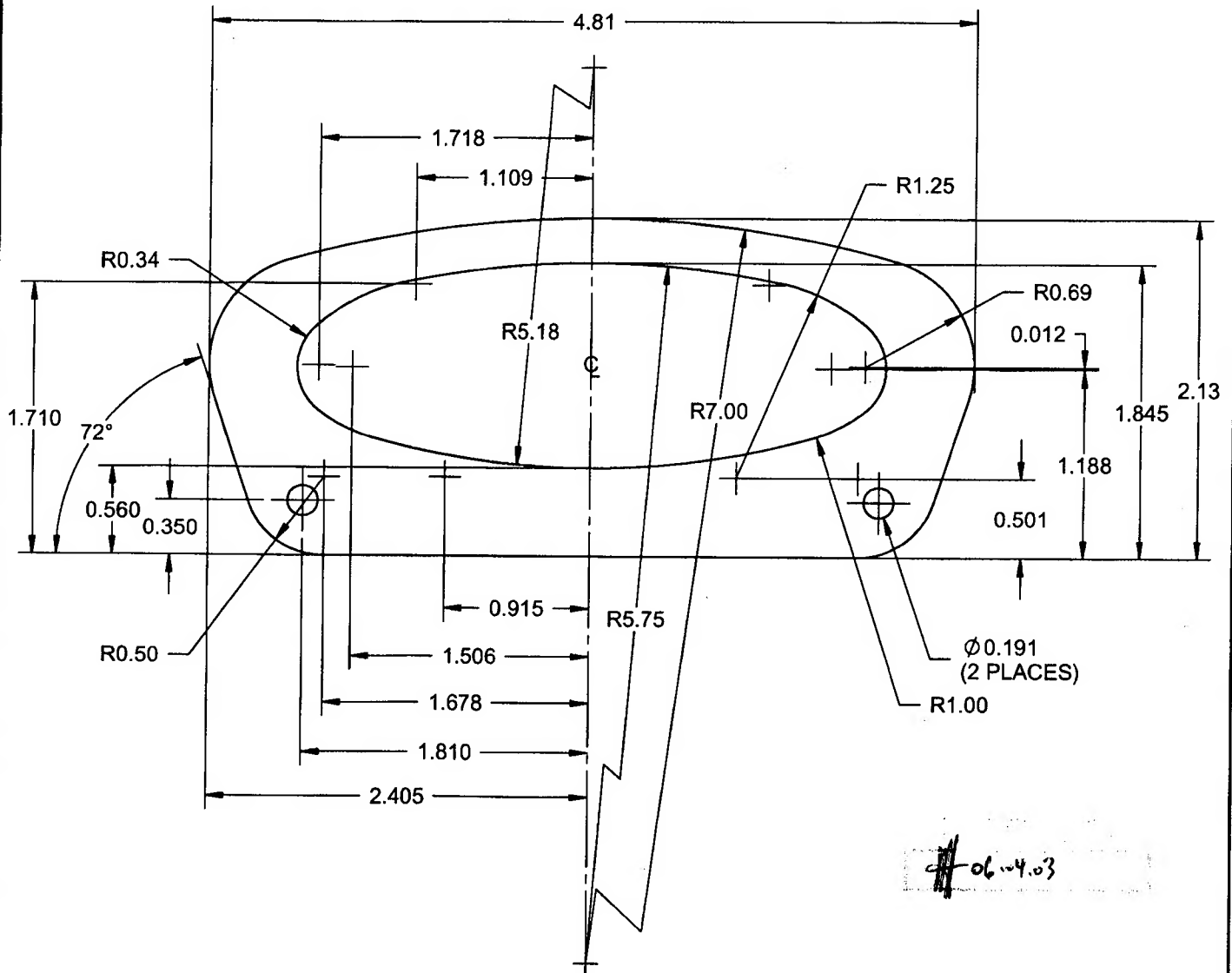
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DATE 06.01.19		TITLE ADAPTER INLET	SCALE 1:1

**D3479-7 FLANGE PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 8

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Sylvia Boacher
Joint Welding Procedure spot weld
Part number and Job number A34791 / B28571

TEST WELDS REQUIRED

BASE METAL S.S. WELDING PROCESS spot weld
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/19 Qualifier David Daniel